

Date: Friday, 5/19/2006 9:49:35 AM
 User: Linda Lacelle

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG
 Job Number : 26625
 Estimate Number : 10337
 P.O. Number :
 This Issue : 5/19/2006 S.O. No. :
 Prsht Rev. : NC Part Number : D28073
 Drawing Number : D2807 REV C
 Project Number : N/A
 First Issue : 4/10/2006 Type : MACHINED PARTS Drawing Revision : C
 Material :
 Due Date : 4/17/2006 Qty: 55 Um: Each
 Previous Run : 23479
 Written By :
 Checked & Approved By :
 Comment : Est A 05.06.02 New Issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303R0750 303 Round Bar .75"



Comment: Qty.: 0.1094 f(s)/Unit Total : 5.4705 f(s)
 Material: 303 Round Bar Ø0.750"
 (M303R0.750)

Batch:

M100415

M100629 (new material)

MR 0605105

38

06/04/07

50

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE

Turn as per Folio FA529 and Dwg D2807 Dwg Rev: C

2-Deburr

06/04/20

50

88 PTO

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/04/20

18

55 split

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: Haas #1

Machine as per Folio FA528 and Dwg D2807 Dwg Rev: C

Folio Rev: C

2-Deburr

J.F

06/05/07

50

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F 06/05/07

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/04/21	2.0	34 parts affected when drill went too deep Drill was about .050 too deep	CP 06.04.21 per QSI 042	Scrap + Replace	06/04/21	06/04/21	CP 06.04.21 per QSI 042	06/04/21

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/05/21

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Friday, 5/19/2006 9:49:36 AM
User: Linda Lacolle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 26625

Part Number: D28073

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 06/05/08

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST

50

SB 06/05/03

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

50

DP 06/05/09

Job Completion



W 06-05-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

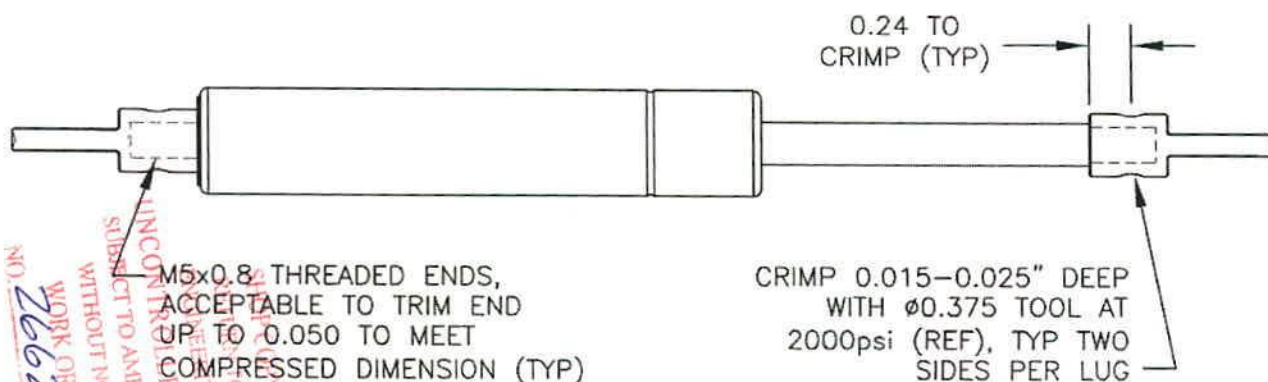
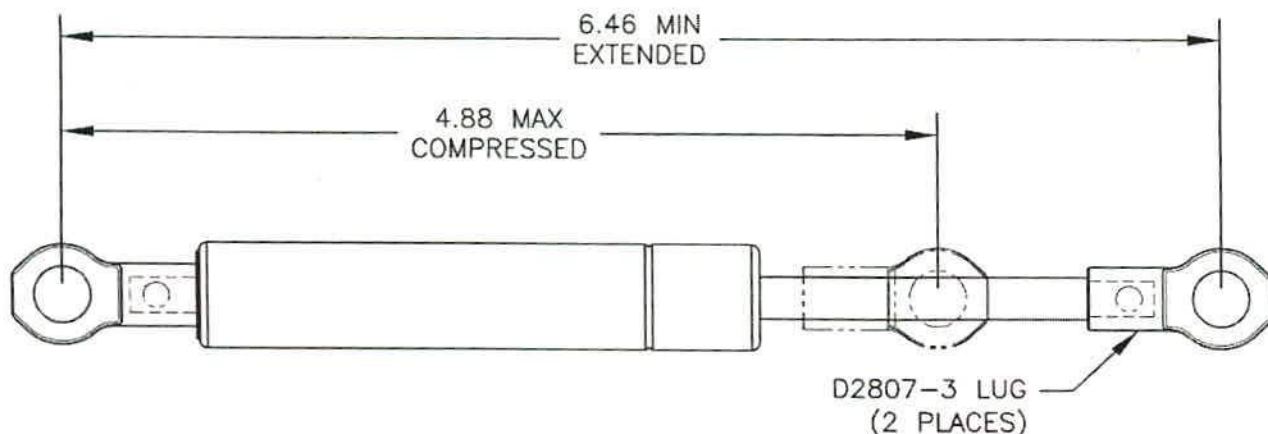
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART**RELEASED**
#05-06-16

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D2807
DATE		TITLE
05.05.25		GAS SPRING
	A	00.11.03
	B	05.03.16
	C	05.05.25
		NEW ISSUE
		ADD FINISH
		CHANGE SPRING TO SS, ADD -3 LUG
		SCALE
		1:1
		SHEET 1 OF 2
		REV. C

**D2807 GAS SPRING**

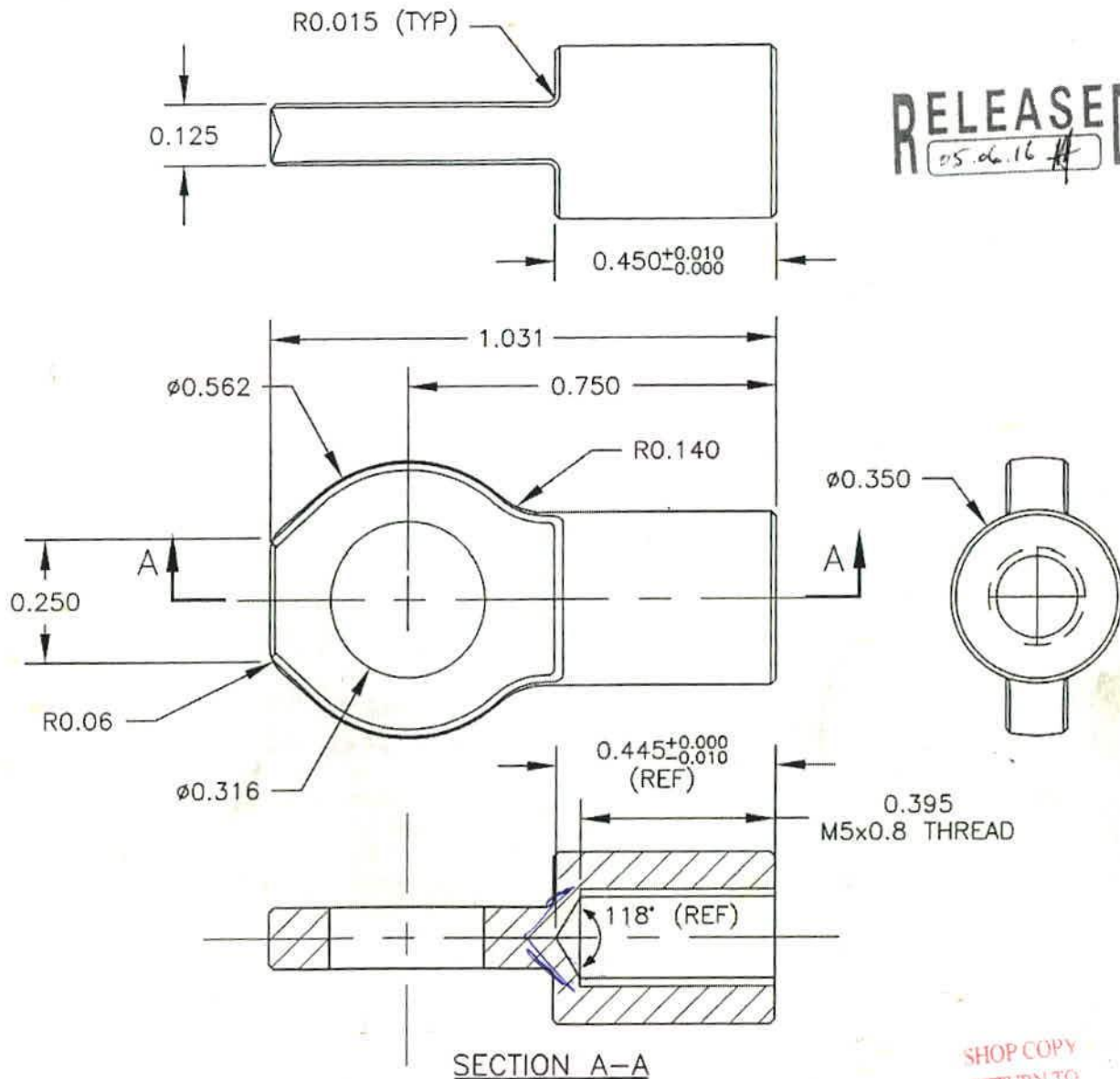
- 1) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25	TITLE GAS SPRING		SCALE 3:1

**D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26625

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

